

Work Order ID 120097

120097

Page 1

Wednesday, June 04, 2014 2:55:44 PM

Item ID: D3489-3-200 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Pip Pin

Start Date: 6/04/14 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: ML3 Date: 14-06-05 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3489	Rev A

100 PURCHASING 0.00

100

Purchasing Memo 0.00

Purchasing Issue P/O: 24549 P/N: 806206 Possible Supplier: Jergens

CL 14/06/11 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging Memo 0.00

Packaging Ensure material certification is attached

P 14/6/13 (10)

120 QC6- Inspect dimensions to drawing 0.00

120

QC Memo 0.00

Quality Control

10

68-6
27
DAS
14/6/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 120097

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Page 2

Wednesday, June 04, 2014 2:55:44 PM

Item ID: D3489-3-200 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pip Pin
 Start Date: 6/04/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

10X DAS 28 JUN 16 2014 9-89

MLJ 14-06-16

14-6-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Wednesday, June 04, 2014 2:55:44 PM

Page 1

Work Order ID: 120097

120097

Parent Item: D3489-3-200

D3489-3-200

Parent Item Name: Pip Pin

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
806206		Purchased	No			100	Each	0.0000	1	10			

806206

PIP PIN

**

P-14/6/13 (10)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3489	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE PIP PIN	SCALE NTS
A	06.01.04	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

1) SPECIFICATION: D3489-X-YYY PIP PIN

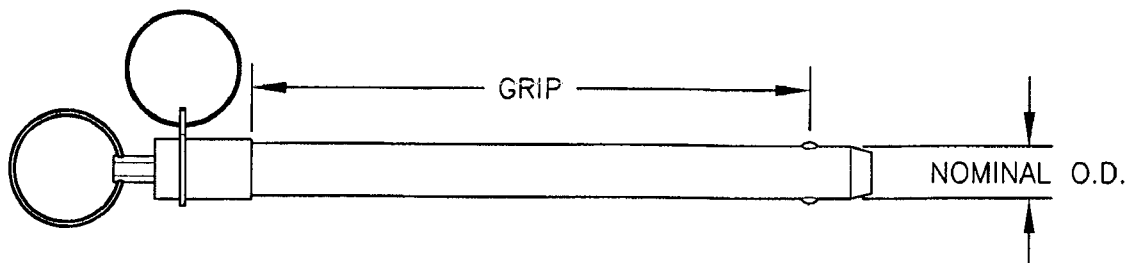
WHERE 'X' IS THE NOMINAL SIZE IN 1/16THS OF AN INCH
AND 'YYY' IS THE GRIP LENGTH IN TENTHS OF INCHES

FOR EXAMPLE, D3489-3-050 IS 3/16" NOMINAL O.D. WITH 0.50" GRIP

2) ACCEPTABLE SUPPLIERS / PART NUMBERS TO PURCHASE

DART P/N	Nominal O.D.	GRIP	Possible Suppliers	
			JERGENS	REID
D3489-3-050	3/16"	0.50	806200	DARS-000D
D3489-3-075	3/16"	0.75	806201	-
D3489-3-100	3/16"	1.00	806202	DARS-001
D3489-3-125	3/16"	1.25	806203	-
D3489-3-150	3/16"	1.50	806204	-
D3489-3-175	3/16"	1.75	806205	-
D3489-3-200	3/16"	2.00	806206	DARS-004
D3489-3-250	3/16"	2.50	806208	DARS-005
D3489-3-300	3/16"	3.00	806209	-
D3489-4-050	1/4"	0.50	806216	DARS-009
D3489-4-075	1/4"	0.75	806217	-
D3489-4-100	1/4"	1.00	806218	-
D3489-4-125	1/4"	1.25	806219	-
D3489-4-150	1/4"	1.50	806220	DARS-020
D3489-4-175	1/4"	1.75	806221	-
D3489-4-200	1/4"	2.00	806222	DARS-030
D3489-4-250	1/4"	2.50	806224	DARS-035
D3489-4-300	1/4"	3.00	806225	DARS-040
D3489-4-400	1/4"	4.00	808227	DARS-050

- 3) DESCRIPTION: DOUBLE ACTING, STAINLESS STEEL, QUICK-RELEASE
BALL LOCK PINS WITH RING HANDLE
- 4) MATERIAL: STAINLESS STEEL. MIN. PULL OUT STRENGTH = 200LBS (3/16" PINS)
OR 230LBS (1/4" PINS). MIN. DOUBLE SHEAR = 5150LBS (3/16" PINS) OR
9200LBS (1/4" PINS).
- 5) ALL DIMENSIONS ARE IN INCHES



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RELEASED
06-03-21 16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120094 MJS
1406-01



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24549**

Purchase Order Date 6/11/2014

PO Print Date 6/11/2014

Page Number 6 of 6

Order From :

VC-HAS001

Ship To : DART AEROSPACE LTD

HASKINS INDUSTRIAL
5-52 ANTARES DRIVE
NEPEAN, ON K2E 7Z1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 723 8800

Ship To Contact

Ship To Phone

Ship Via: Dicom

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

17	806206	PIP PIN	6/16/2014	10.00	\$22.82	\$228.20
			Yes	Each		
			6/16/2014			

AS PER DWG D3489 REV. A
B120097

Line Total: \$228.20

18	71401-45	PROCUREMENT QUALITY CLAUSES	6/16/2014	1.00	\$0.00	\$0.00
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No

PROCUREMENT QUALITY CLAUSES (REQUIRED FOR
LINE 15,16,17)

6/16/2014

A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

PO Total: \$2,502.74

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 6/11/2014

HASKINS INDUSTRIAL INC.
5-52 ANTARES DRIVE

** PACKING SLIP **

Order # --1253921.00

Order Date 06/11/14

NEPEAN, ONTARIO K2E 7Z1
TEL (613)723-8800 FAX (613)723-8806

Page 2 of 2

Sold To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

Ship To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

* Reprint *

Cust Phone #	Warehouse	F.O.B.	Taken By
	OTTAWA	DEST	Sylvie 613-723-880

Cust #	Customer P/O #	Required	Orig Order	Slsm	Ship Via	Terms
05168	24549	06/12/14	1253921.00	PL	DICOM	NET 30

Ln#	Bin #	Order UM	Ship	B/O	Product	Description
12		20 EA	20		KEO1X1 1158624	CNMG432K KC935 INSERT
13		20 EA	0	20	KEO1X1 3760355	DNMG432MP KCM25 INSERT
DNMG 432MG KC935 NO LONGER AVAILABLE						
14 *		1 EA	0	1	SO1X1 Q#S97392	894383 100TG-NUT LYNDX
15	CAB810	500 EA	500		MMS-D3672-1	.437 X .210 X .031 +/- .002 WASHER, PHENO
16	CAB810	500 EA	500		MMS-D3672-7	.562 X .328 X .031 +/- .002 WASHER, PHENO
17	030220	10 EA	10		JG-806206	3/16 DBL ACTION RING HANDLE 806206

PLEASE NOTE:

1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED
CL= QTY NOT SHIPPED WAS CANCELLED
SC= ITEM CONSIDERED COMPLETE - NO B/O CREATED

FILL PACK DATE
Printed on 2014-06-12 at 10:30

6/12/14